



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6005G01531-3G-PO

Job Sheet 191230



Part No: RBW6005G01531-3G-PO **Job Qty:** 2 pcs

Part Name: Dial Indicator Main Rotor Damper Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/25/19

Job Tracking No:

Due Date: 4/22/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6005G01531-3G Rev.2 IPP Rev. A 18.10.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
100	Purchasing	2 pcs	04/22/19	4/22/19	0.00	0.00	Purchasing - 1	
							Purchasing - 2	
							Purchasing - 3	DP APR 2 5 2019
110	Packaging 2-1 - Receive - B4B	2 pcs	04/22/19	4/22/19	0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	DP APR 2 5 2019
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	



Dart Aerospace Ltd.
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S175265



Part: RBW6005G01531-3G

Job No: 191230

Serial No/Batch: S175265

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 04/25/19

Plex 2/25/19 9:58 AM dart.Lussier.Patrick

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120	QC 6	2 pcs	4/22/19	0.00 0.00	QC 6 - 42	MAY 13 2019 DAS 40 9-89
					QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
130	Packaging 3-1 - Stock - B4B	2 pcs	4/22/19	0.00 0.00	Packaging 3 - 1 - B4B	DAS 28 9-89
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - FG	2 pcs	4/22/19	0.00 0.00	QC 21 - FG - 21	DAS 21 9-89 MAY 13 2019
					QC 21 - FG - 70	
					QC 21 - SA - 53	

Part Op 100 - (Purchasing) Issue P/O: 042689 MANUFACTURE RBW6005G01531-3G AS PER DWG Supplier: METEC
 Descriptions: Certificate of conformity is required

- 110 - (Receive & Inspect for Damage & Mat'l Certs)
- 120 - (QC6- All purchased or subcontracted products)
- 130 - (Identify as per dwg & Stock Location: _____)
- 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6005G01531-3GP	Dial Indicator Main Rotor Damper Support	2 pcs (1 ea)	100-Purchasing	S175262

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6005G01531-3GP	2	0	0

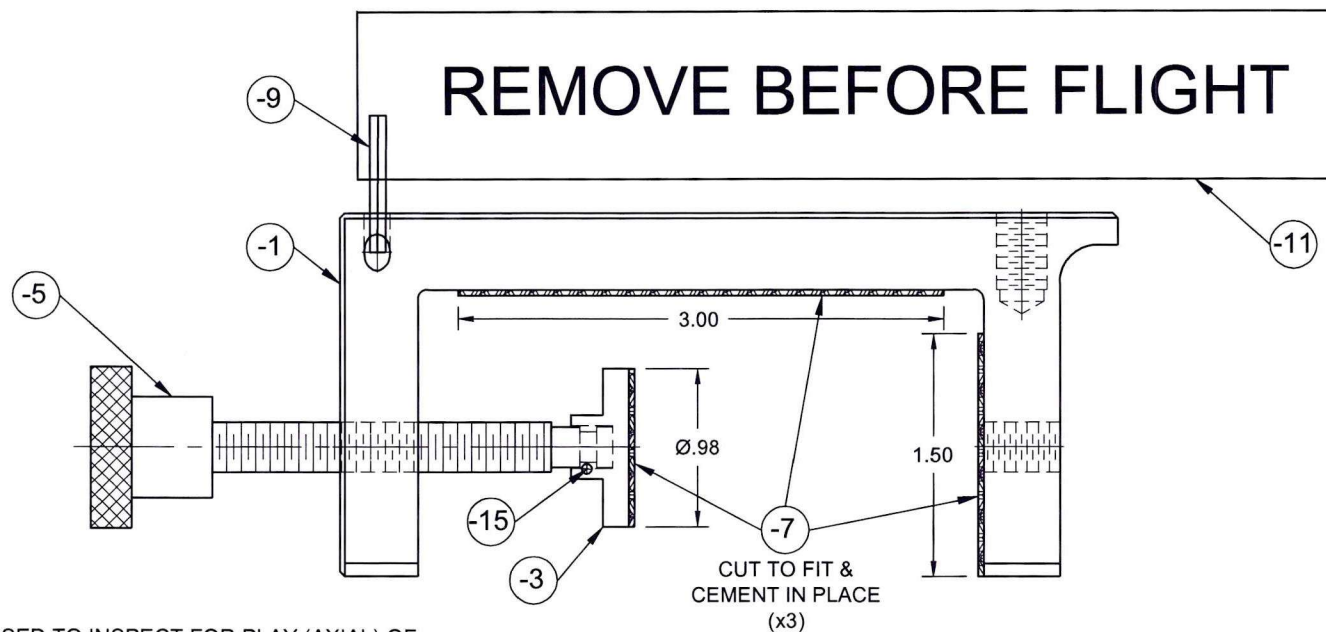
Part Specifications

Specifications could not be found.

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REVISIONS					
REV	DESCRIPTION	DATE	INITIAL	APPROVED	
1	REPLACED THUMB NUT, ALL THREAD & ROLL PIN WITH THUMB SCREW.	3/20/09	WP	DW	
1A	CH'D ENGRAVE NOTE P/N -1.	5/28/09	RJC	RW	
2	CH'D P/N -11 FROM NAS1756-18 IN BOM, ADDED MISSING DIM'S .240, 4.213 & DEPTH 12.7MM FOR P/N -1, CH'D RADIUS FROM .230 ON P/N -1 PER G.E.	10/26/09	RJC	RW	



FUNCTION: USED TO INSPECT FOR PLAY (AXIAL) OF THE MR DAMPER SPHERICAL BEARINGS (HUB SIDE), WITHOUT REMOVING THE COMPONENTS FROM THE AIRCRAFT.

ORIGINAL No. REF.
RBW6005G01531 $\equiv$ 3G6005G01531
RBW6005G01531-1 $\equiv$ 3G6005G02731
RBW6005G01531-11 $\equiv$ 999-3900-17-3
DO NOT USE, FOR REFERENCE ONLY.

ASSY QTY	ASSY #	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS
			-1	1	CLAMP FRAME	304 S.S. FLAT BAR	1 x 2-1/2 x 5
			-3	1	SWIVEL END	304 S.S. RND. BAR	Ø1 x 1/2
		MACH	-5	1	THUMB SCREW	S.S.	MCMaster-CARR #6091K47
		B/O	-7	1	PAD MATERIAL WITH ADHESIVE BACK	RUBBER	.036 x 1 x 5-1/2 GASKET SPECIALTIES
		B/O	-9	1	SPLIT RING	PLATED	Ø7/8 x .11 thick MCMaster-CARR #90177A217
		B/O	-11	1	FLAG	PLASTIC WEAVE	NAS1756-12
		B/O	-15	1	DOWEL PIN	S.S.	Ø1/16 x 5/16
	ASSY #						

RED BARN MACHINE

TITLE	SUPPORT, DIAL INDICATOR MAIN ROTOR DAMPER ASSEMBLY
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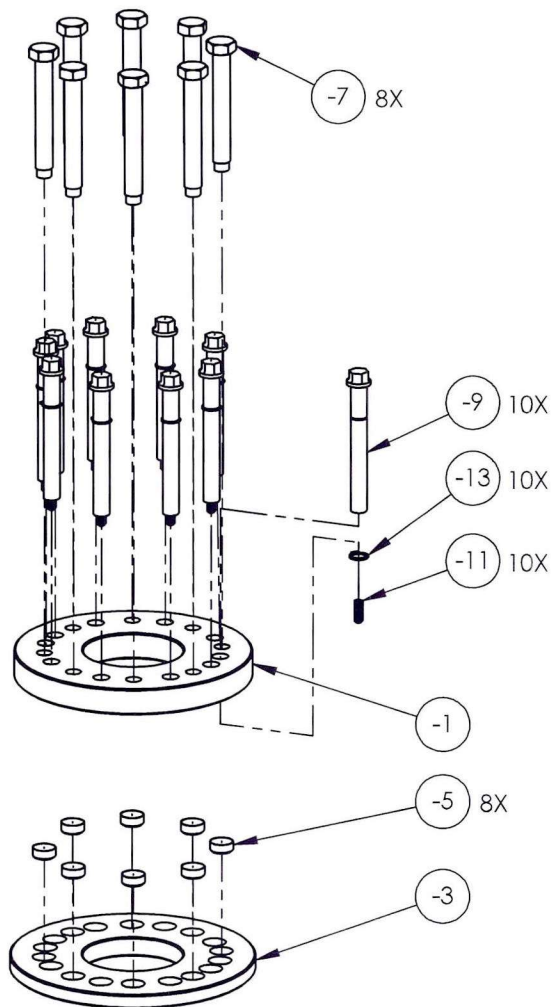
DWG NO.	RBW6005G01531-3G	REV
		2

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT
TOLERANCES ON:		APPROVED <i>D Weid</i>
DECIMALS		HEAT
.XXX ± .005	FRACTIONS ± 1/32	TREAT
XX ± .01	ANGLES ± .5°	FINISH
X ± .1		SPEC

UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
	AGUSTA

SCALE	NTS	DATE	1-22-09	SHEET	1 of 2
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0288	ADDED NOTE 3, SHT 1, ADDED VIEW TO SHOW DIM OF ASSEMBLED -11 INTO -9. -1 CH'D DIM WAS Ø.355 THRU IS Ø.3564-.3555 THRU. -5 CH'D MATERIAL CALLOUT WAS 4140 IS 4140/4142. -9 CH'D DIMS WAS 10-24 UNC X 1/2. -11 CH'D DIM WAS 10-24 UNC X 1/2.	9/2/2015	RJC	JAG
3	17-0143	-1 CH'D DIMS WAS 10X Ø.3564/.3555 THRU IS 10X Ø.359/.357 THRU ALL, WAS 1.800 IS 2X 1.800, WAS 1.355 IS 2X 1.355, WAS .875 IS 2X .875, WAS .282 IS 2X .282, WAS .282 IS 2X .282, WAS .875 IS 2X .875, WAS 1.355 IS 2X 1.355, WAS 1.800 IS 2X 1.800, WAS 1.908 IS 2X 1.908, WAS 1.719 IS 2X 1.719, WAS 1.373 IS 2X 1.373, WAS .695 IS 2X .695, WAS .695 IS 2X .695, WAS 1.373 IS 2X 1.373, WAS 1.719 IS 2X 1.719, WAS 1.908 IS 2X 1.908. CH'D ENGRAVE NOTE WAS ENGRAVE P/N: "RBW1805G03351-3G" IS ENGRAVE P/N. -3 CH'D DIMS WAS 8X Ø.192 THRU ALL Ø.500 X .210 IS 8X Ø.192 THRU ALL Ø.5007/.5000 X .210 (P.F.-5), WAS 1.800 IS 2X 1.800, WAS 1.355 IS 2X 1.355, WAS .875 IS 2X .875, WAS .282 IS 2X .282, WAS .282 IS 2X .282, WAS .875 IS 2X .875, WAS 1.355 IS 2X 1.355, WAS 1.800 IS 2X 1.800, WAS 1.908 IS 2X 1.908, WAS 1.719 IS 2X 1.719, WAS 1.373 IS 2X 1.373, WAS .695 IS 2X .695, WAS .695 IS 2X .695, WAS 1.373 IS 2X 1.373, WAS 1.719 IS 2X 1.719, WAS 1.908 IS 2X 1.908. CH'D ENGRAVE NOTE WAS ENGRAVE P/N: "RBE1805G03031-3G" IS ENGRAVE P/N. -5 CH'D DIMS WAS Ø.500 IS Ø.5016/.5012 (P.F.-3), WAS R1.00 IS SR1.00. ADDED DIM .03 X 45°. -7 DELETED DIMS 2.75, .200. ADDED DIMS 2.76, .213, SR 1.00. -9 CH'D DIM WAS .375 IS 3X .375/.362, WAS Ø.3550/.3544 IS .355/.353, WAS (.750) IS .75.	6/19/2017	RJC	JAG

NOTE:

1. REF. AUGUSTA T/N: 3G1805G01731.
2. ALSO PART OF KIT RBW1805G01431-3G, REF. AUGUSTA T/N: 3G1805G01431.

3 USE PERMANENT LOCTITE.

DART AEROSPACE	
TITLE MVA REMOVAL TOOL	
DWG NO. RBW1805G01731-3G	REV 3
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/√
DRAWN BY: SMITH CHECKED: DD 06/22/2017 OPPS APPR: AA 06/26/2017 QA APPR: JL 06/28/2017 APPROVED: JAG 07/03/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:4	DATE 4/25/2013
SHEET 1 OF 6	

ASSY QTY	ASSY QTY	B/O	Part #	QTY.	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	TOP PLATE	S.S.		2
			-3	1	JACK PLATE	S.S.		3
			-5	8	BUTTON	4140/4142		4
			-7	8	JACKING SCREW	S.S.	3/8-24 X 3 (MCMASTER-CARR #93190A373) MODIFIED	5
			-9	10	PULL SCREW	S.S.		6
		B/O	-11	10	SET SCREW	S.S.	10-24 UNC X 1/2 (MCMASTER-CARR #94355A227)	1
		B/O	-13	10	RETAINING RING	S.S.	Ø3/8 (MCMASTER-CARR #91590A117)	1



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO042699**



Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042699

PO Date: 2/25/19

Due Date: 4/22/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	191228	RBW1805G01731-3GP			Mast Vibration Absorber Removal Tool REV 3	Firmed	-	4/22/19	2 Ea	0 Ea	2 Ea	\$1,280.00/Ea	\$2,560.00
2	191230	RBW6005G01531-3GP			Dial Indicator Main Rotor Damper Support REV 2	Firmed	-	4/22/19	2 pcs	0 pcs	2 pcs	\$900.00/pcs	\$1,800.00
3	191231	RBW6205G03632-3GP			Main Rotor Trim Tab Bending Tool REV 2	Firmed	-	4/22/19	2 Ea	0 Ea	2 Ea	\$897.00/Ea	\$1,794.00
4	191232	RBW6205G03832-3GP			Main Rotor Blade Blocking/Protecting Assembly REV 5	Firmed	-	4/22/19	2 Ea	0 Ea	2 Ea	\$2,065.00/Ea	\$4,130.00

Grand Total: \$10,284.00

DAS
40
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042699



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 2/25/19 10:14 AM dart.Lussier.Patrick



METAL TECHNOLOGY INC.

www.metec.ca | 20 Terry Fox Drive, Vankleek Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Att. Patrick Lussier
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 24999
Shipment Date: 15-Apr-2019
Ship Via: Pick up at METEC
Order Number: 3543
Order Date: 02/25/19

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO042699
Terms: Net 60 Days

----- Quantity -----								
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Job Number</u>
2	2	2	0	0	EA	RBW6005G01531-3GP Dial Indicator Main Rotor Damper Support	2	3543-02

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By
Att. Patrick Lussier



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	P.O. Number
2	RBW6005G01531-3GP	Dial Indicator Main Rotor Damper Support	2	42699

MATERIAL: supplied by METEC

DAS
40
9-89

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

George Theoret

Vankleek Hill, April 15, 2019